

Work Order ID 124659

124659

Page 1

Thursday, September 18, 2014 3:01:11 PM

Item ID: 41228-202-101-001

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 412 Radius Doubler

Start Date: 9/18/2014 Start Qty: 42.00

42

Cust Item ID:

Required Date: 9/18/2014 Req'd Qty: 42.00

42

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1409-18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
41228-202-101	D

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

0.00

DAS

37

9-89

(50)

DC 14/09/22

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

DAS

37

9-89

(50)

DC 14/09/22

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124659

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N900040100

Setup Start *NS1*

Item Name: 412 Radius Doubler

Stop *NS2*

Start Date: 9/18/2014 **Start Qty:** 42.00

42

Cust Item ID:

Required Date: 9/18/2014 **Req'd Qty:** 42.00

42

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

**Insp.
Stamp**

Manufacture as per dwg

0.00

130

0.00

Mill Conv

Conventional Milling Machine

Memo

MILL RADIUS AS PER DWG

HOLE ARE NOT CENTER MAKE RAD ON GOOD SIDE

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

0.00

OC

Quality Control

Memo

150

QC8- Inspect parts - second check

0.00

150

0.00

QC

Quality Control

Memo

encl 14/09/30

50



**DAS
14
9-89**

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DAS
28 OCT 08 2014
9-89

Work Order ID 124659***124659***

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Thursday, September 18, 2014 3:01:11 PM

Item ID: 41228-202-101-001

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 412 Radius Doubler

Stop ***NS2***

Start Date: 9/18/2014 Start Qty: 42.00

42

Cust Item ID:

Required Date: 9/18/2014 Req'd Qty: 42.00

42

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

14/10/9  410-9

Picklist Print

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Work Order ID: 124659

124659

Parent Item: 41228-202-101-001

41228-202-101-001

Parent Item Name: 412 Radius Doubler

Start Date: 9/18/2014

Required Date: 9/18/2014

Start Qty: 42.00

Required Qty: 42.00

Comments: IPP REV:A 14.09.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

sf

345.6339

1

DAS

37

9-19

12/14/09/22

M2024T3S 063

**

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

345.6339

123701

16.1039

m127866

29.93

m128354

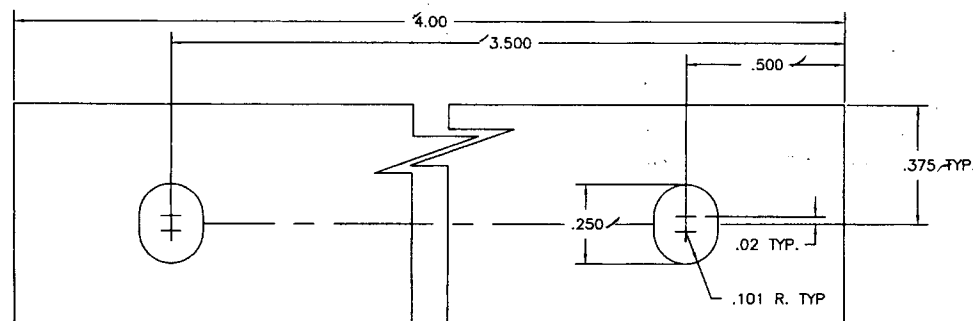
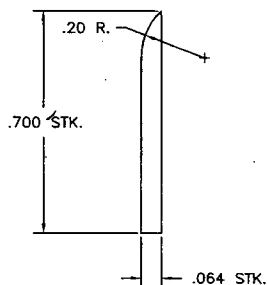
35

m130000

264.6

1.53

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124689 MLJ
1409-18



REVISION				APPROVED	DATE
LETTER	DFTSMAN	DATE	DESCRIPTION		
A	TAH	12/4/92	CHANGED LENGTH FROM 1" TO 4" & ADDED SECOND HOLE. CHANGED NAME OF PART FROM WASHER TO RADIUS DOUBLER	PAS	12/4/92
B	TAH	9/22/93	CHANGED MATERIAL SPEC. No.		
C	TAH	10/28/93	REVISED NOTE 1		
D	DNN	12/14/95	INCORPORATED E.O. D-1.		

D. HARVEY 2/27/96
265-96-12
P. SCHWARTZ 3/21/96
96.014 3/21/96
96.015 3/21/96
96.016 3/21/96

△ CHEMICAL SURFACE TREAT PER MIL-C-5541E, CLASS 1A. ©

NOTE:

-001		WASHER		TIERNAY 60-16094	2024-T3511 QQ-A-200/3 (ALT MAT'L 7075-T6-511) ©
PART NO.		NAME		STOCK SIZE	MATERIAL
NO. REQ'D PER ASSY		LIST OF MATERIAL		MATL SPEC	ZONE
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED		DRAFTS MAN T. HARVILLE 8/31/92	
THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE, IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FORGEWORK DOES NOT APPLY TO VENDOR PARTS.		X ± .1 XX ± .03 XXX ± .010 ANGLES ± 1/2°		CHECK D. MURPHY 9/2/92 STRESS P. SCHWARTZ 9/2/92 PROJ. ENGR.	
-001 12 41228-200-004		NEXT ASSEMBLY		TITLE RADIUS DOUBLER	
DWG. NO. 41228-202-101		SCALE 4=1		DWG. NO. 41228-202-101 D	

Era Aviation, Inc.

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	